

S/N 24/07

Dart Aerospace Ltd.

Date: Wednesday, 7/11/2007 3:06:00 PM
 User: Kim Johnston

Process Sheet

| | | | | | |
|-----------------------|--|--|------------------|------------------------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : PLATE | |
| Job Number | : 33513 | | | | |
| Estimate Number | : 12563 | | | | |
| P.O. Number | : N/A | | Part Number | : D323813 | |
| This Issue | : 7/11/2007 S.O. No. : N/A | | Drawing Number | : D3238 REV.C | |
| Prsh Rev. | : NC | | Project Number | : N/A | |
| First Issue | : N/A | | Drawing Revision | : C | |
| Previous Run | : N/A | | Material | : N/A | |
| Written By | | | Due Date | : 7/23/2007 Qty: 12 Um: Each | |
| Checked & Approved By | | | | | |
| Comment | : Est Rev:A New Issue 06-10-20 EC | | | | |
| | Est Rev:B Now on Waterjet 07-01-26 JLM | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|--|
| 1.0 | M5052H32S020 | 5052-H32 .020 Sheet |
| | | Comment: Qty.: 0.0126 sf(s)/Unit Total : 0.1512 sf(s) 5052H32 aluminum sheet 0.020" thin batch: m 3019 HB 07-07-19 |
| 2.0 | WATER JET | FLOW WATER JET |
| | | Comment: FLOW WATER JET 1-Cut as per Dwg D3238 Dwg Rev: C Prog Rev: C HB 07-07-19 2-Deburr if necessary SAD 07/07/20 |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| | | HB 07-07-19 |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE |
| 4.0 | QC8 | SECOND CHECK |
| | | center En 07/07/20 X12 12X |
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
| | | Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 m-f 07/07/23 |

| W/I/O: | | WORK ORDER CHANGES | | | | | |
|--------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/02/24
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 7/11/2007 3:06:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 33513

Part Number: D323813

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/7/25 rx SP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

7/7/23 (rx) SP

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(12)

Comment: FINAL INSPECTION/W/O RELEASE

7/7/23 (12) SP

Job Completion



7/7/23

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 33513 |
| Description: Plate | Part Number: | D3238-13 |
| Inspection Dwg: D3238 | Rev: C | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | | | | |
|--------------|-----------|-------------|-----------|---------------------|-----|
| Measured by: | <u>HB</u> | Audited by: | <u>CR</u> | Prototype Approval: | N/A |
| Date: | 07-07-19 | Date: | 07/07/20 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|------------|-------------|------------------|-------------------|-----------------|
| A | 07.01.17 | New Issue | KJ/JLM | |
| B | 07.02.23 | Dwg Rev. updated | KJ/JLM | ZB |

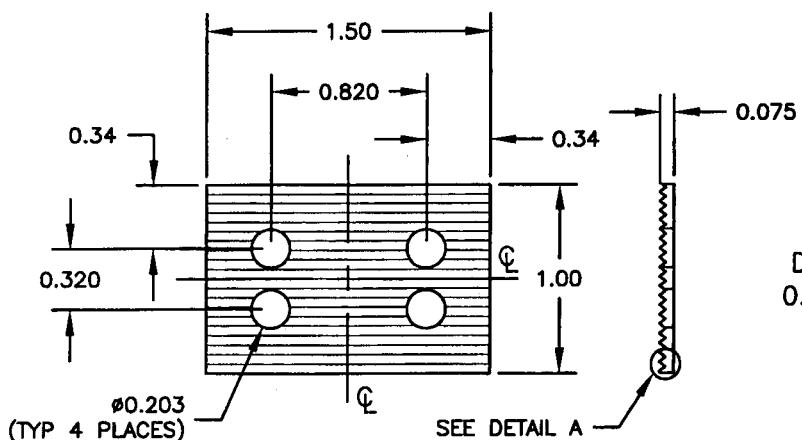
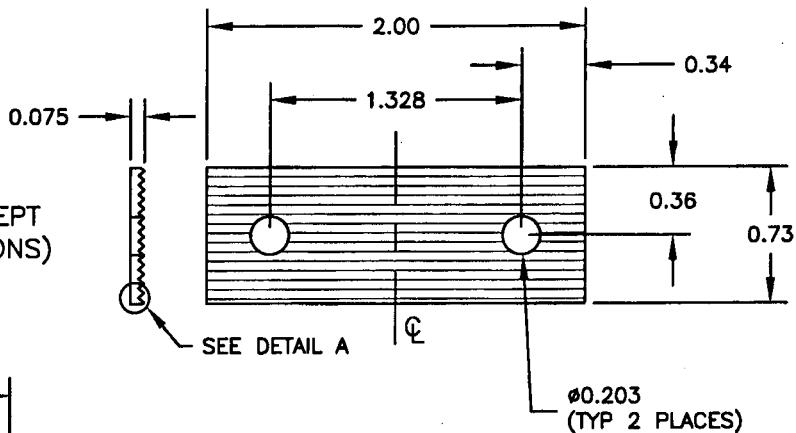
DART

| | | |
|----------------------|-----------------------|---|
| DESIGN <i>CE</i> | DRAWN BY <i>CB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED <i>CE</i> | APPROVED <i>CB</i> | DRAWING NO. D3238 |
| DATE 07.02.19 | | REV. C SHEET 1 OF 3 |
| | | TITLE PLATE |
| | | SCALE 1:1 |
| A | 03.11.25 | NEW ISSUE |
| B | 07.01.17 | ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6 |
| C | 07.02.19 | ADD 5052-H32 OPTION |

RELEASED

07.02.20 *CB*

D3238-1 PLATE (SHOWN)
 D3238-11 PLATE (SAME, EXCEPT
 0.020 THICK AND NO SERRATIONS)



D3238-3 PLATE (SHOWN)
 D3238-13 PLATE (SAME, EXCEPT
 0.020 THICK AND NO SERRATIONS)

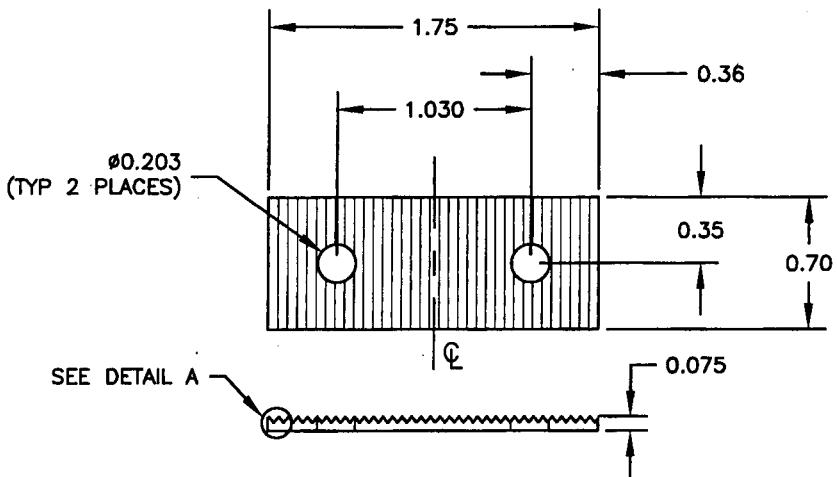
NOTES:

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:
 ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037
 (REF DART SPEC M2024T3S)
- 11/-13/-15/-31/-33/-35 PLATE:
 ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR
 AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
 OR
 ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR
 AMS 4016 (REF DART SPEC M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT $\frac{1}{4}$

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NO. 33513

DART

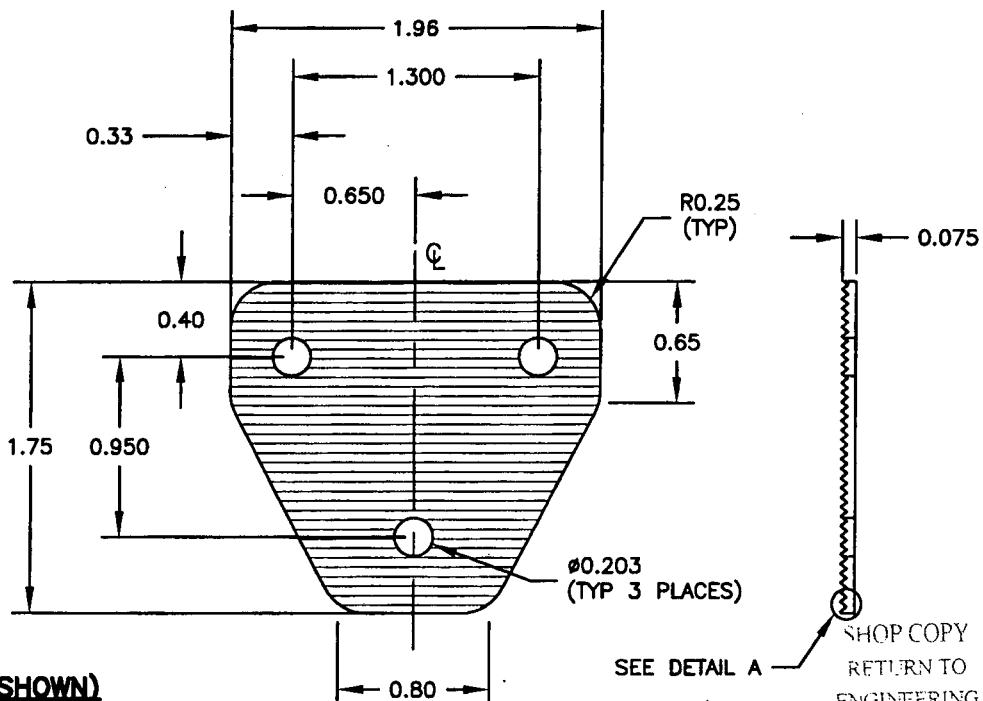
| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>CH</i> | DRAWN BY <i>CB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>CE</i> | APPROVED <i>HF</i> | DRAWING NO. D3238 | REV. C SHEET 2 OF 3 |
| DATE 07.02.19 | TITLE PLATE | SCALE 1:1 | |



RELEASED

07.02.20 *CH*

D3238-5 PLATE (SHOWN)
D3238-15 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



D3238-21 PLATE (SHOWN)
D3238-31 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

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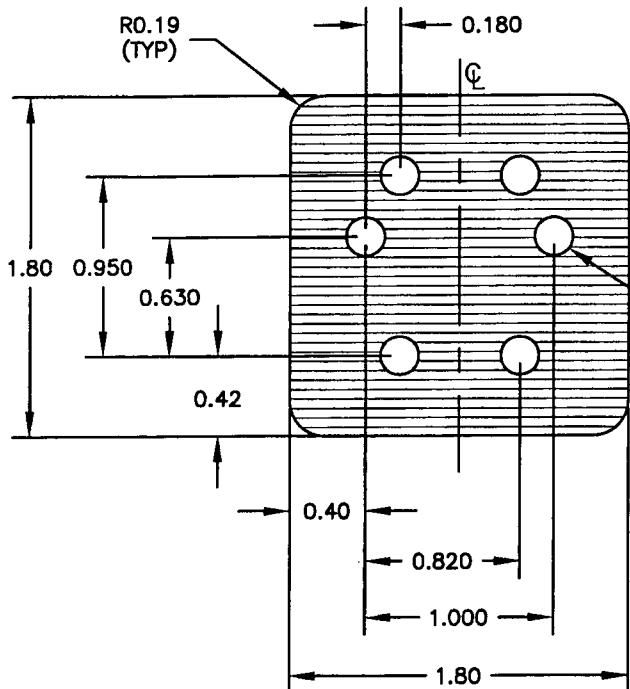
WORK ORDER
33573

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DART

| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>A</i> | DRAWN BY <i>CB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>CE</i> | APPROVED <i>CH</i> | DRAWING NO. D3238 | REV. C SHEET 3 OF 3 |
| DATE 07.02.19 | TITLE PLATE | SCALE 1:1 | |

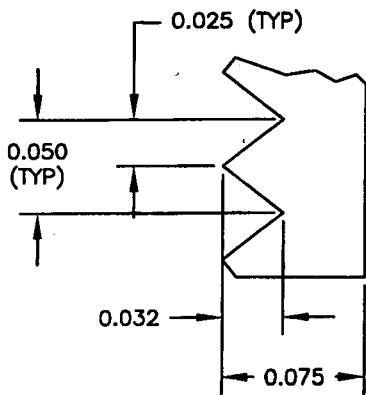


0.075

RELEASED

07.02.20 ~~off~~

D3238-23 PLATE (SHOWN)



RIDGE DETAIL (VIEW MAY BE ROTATED)

This technical drawing illustrates a component's dimensions and features. The overall width is 1.63. A central vertical slot has a width of 1.030 and a depth of 0.515. The top edge features two rounded corners, each with a radius of R0.30 and a length of 0.30. Two circular holes, each with a diameter of Ø0.203, are located at the top of the component. The bottom edge has two rounded corners, each with a radius of R0.25 and a length of 0.203. The total height of the component is 1.43, with a base thickness of 0.075. A note indicates to "SEE DETAIL A".

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